








RUSH

Work Order ID 52194

September 17, 2009 12:42:14 PM


Page 1

Item ID: D3954-7 *FL* Accept  Setup Start 
Revision ID: A
Item Name: Ratchet Lug Stop 
Start Date: 09/17/2009 Start Qty: 1.00  Cust Item ID:
Required Date: 09/21/2009 Req'd Qty: 1.00  Customer:
Reference:


Approvals: Process Plan: *MP* Date: *09-09-17* Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100		0.00
		
Mill Conv	Memo	0.00
Conventional Milling Machine	mill to size	

090917

110		0.00
		
Waterjet	Memo	0.00
FLOW CNC Waterjet	1-Cut as per Dwg D3954	
	Dwg Rev: <i>A</i>	
	Prog Rev: <i>A</i>	
	2-Deburr if necessary	

09-09-18

W/O: 52194

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.09.22	40	Spray paint reel using Chromabase performance reel M112733	VB	09.09.22	1	VB 09.09.22	VB 09.09.22

Part No: D3954-7 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52194

September 17, 2009 12:42:14 PM



Item ID: D3954-7

Accept



Setup Start



Revision ID: A

Stop



Item Name: Ratchet Lug

Start Date: 09/17/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/21/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ml 09 09 22 ①

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

18 09.09.23

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/23 HF
MF 04-09-23

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Page 1

September 17, 2009 12:42:14 PM

Work Order ID: 52194

Parent Item: D3954-7RevA

Parent Item Name: Ratchet Lug

Comments:

Start Date: 09/17/2009

Required Date: 09/21/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304B1.500X1.500		Purchased	No			100	f	14.2900	0.5263			



304 bar 1.50 X1.50

18 9-9-18

~~MIDID B 1.50" X 1.50"~~

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

14.29

108381

14.29

~~111410~~

101741

Batch: 111410

Just 09-09-18
1010 101741

2.5" X 1.75"

101741

~~100667080150X03000~~ okay for
Mild Steel
155
09.29.17

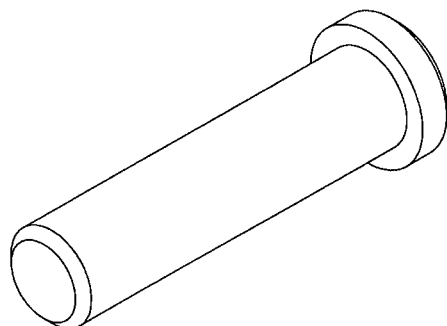
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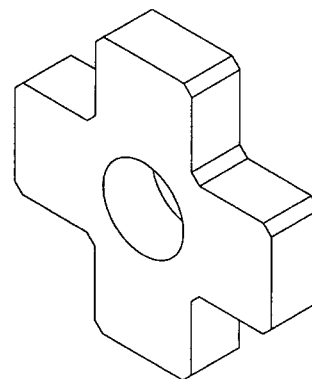
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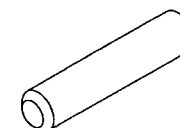


D3954-1 GWT PIN

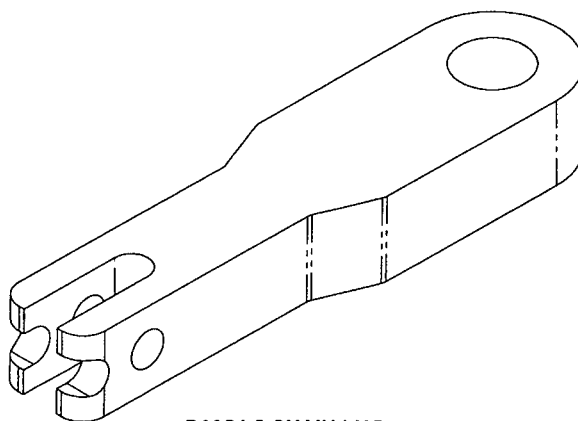


D3954-3 GWT KNOB

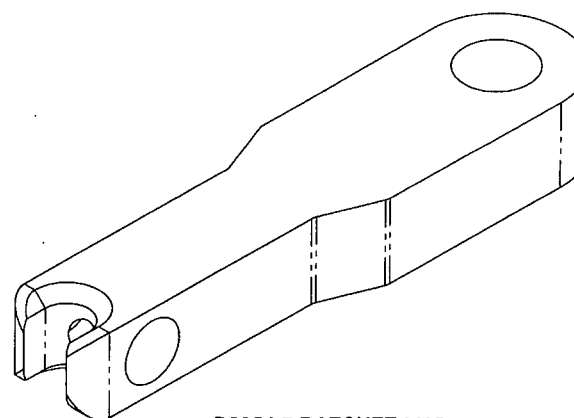
#52194



D3954-9 GWT CHAIN PIN





D3954-5 CHAIN LUG



D3954-7 RATCHET LUG

RELEASED
04/06/02

A		NEW ISSUE		DESCRIPTION		AJS	09.05.26
REV.						BY	DATE
DESIGN		AJS/DSTOW		DART AEROSPACE LTD			
DRAWN		AJS		HAWKESBURY, ONTARIO, CANADA			
CHECKED				DRAWING NO.		REV.	
MFG. APPR.				D3954		SHEET 1 OF 3	
APPROVED				TITLE		SCALE	
DE APPR.		N/A		MISC MACHINED PARTS GWT KIT		NT	
DATE		09.05.26		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

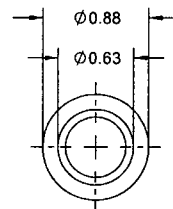
W/O:		WORK ORDER CHANGES					
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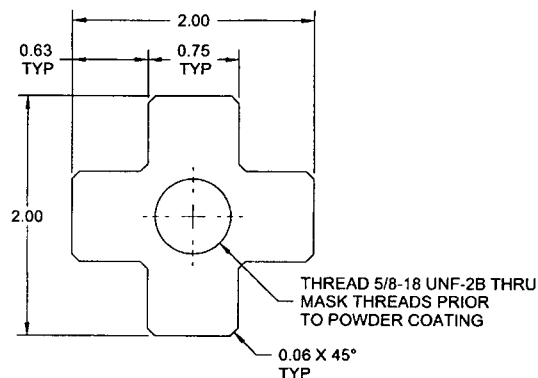
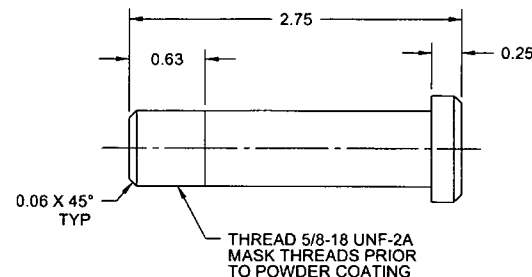
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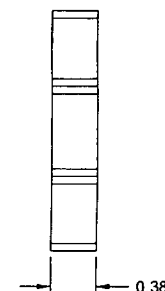
NOTE: Date & initial all entries



D3954-1 GWT PIN



D3954-3 GWT KNOB



NOTES:

1) MATERIAL -1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
PER AMS 5513 OR AMS 5524
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

52194

RELEASED
07/08/02 MP

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	09.05.26	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

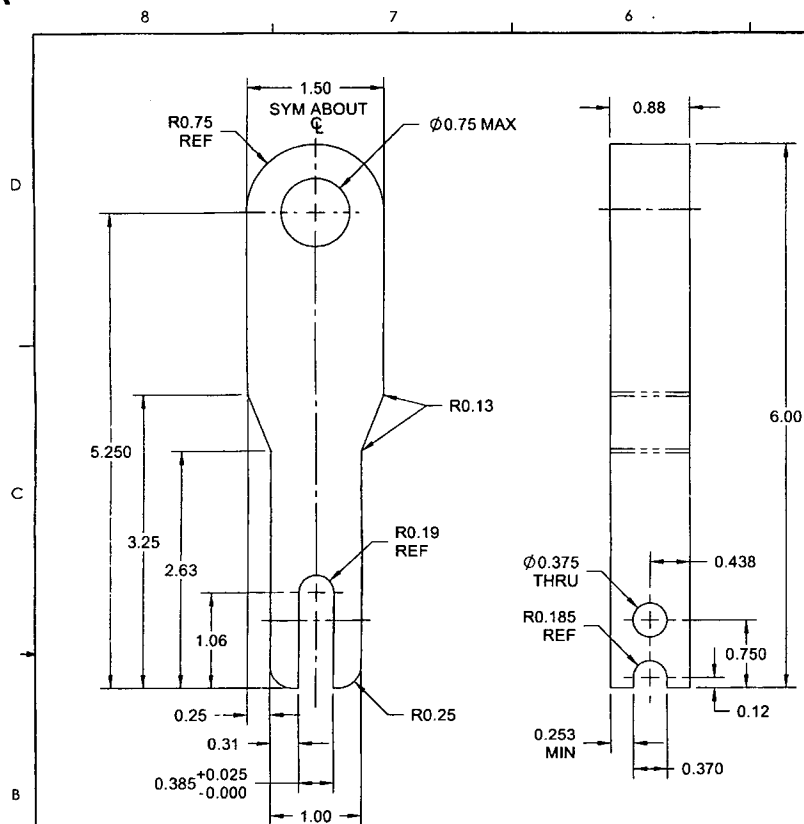
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3954-5 CHAIN LUG

NOTES:

1) MATERIAL -5/-7: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

2) FINISH -7 ONLY: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

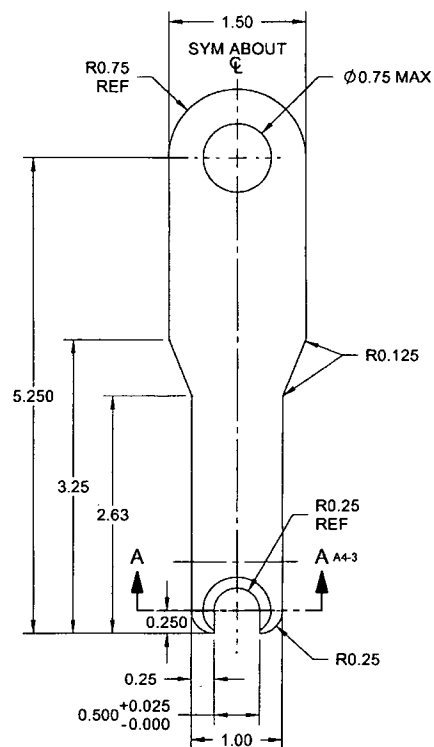
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

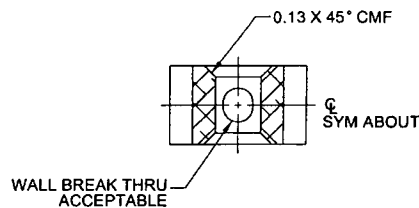
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -5/-7: 1.56 lbs EACH

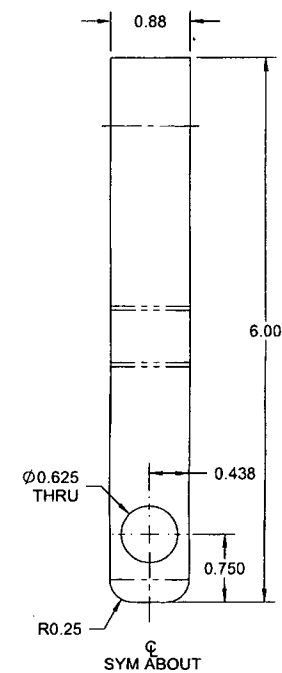
-9: 0.05 lbs



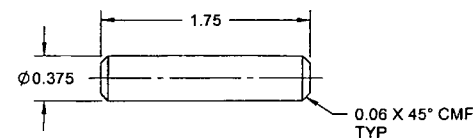
D3954-7 RATCHET LUG




SECTION A-A C3-3



D3954-9 GWT CHAIN PIN



RELEASED
07/06/02

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		N/A	MISC MACHINED PARTS GWT KIT
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